

Work Order ID 69407-1

Tuesday, May 10, 2011 3:25:25 PM



Page 1

Item ID: D2435

Accept



Setup Start



Revision ID:

SPLIT

Item Name: Bearpaw, 206

Stop



Start Date: 5/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan:

Date: 4-05-

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B11-5-1



130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

Y.A 11/08/15

8

8

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Y.A 11/08/15

8

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69407

Tuesday, May 10, 2011 3:25:25 PM



Page 2

Item ID: D2435

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206

Start Date: 5/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

11/08/16

8

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

11/8/16

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/8/18

Quality Control

11-08-16
(8)

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Picklist Print

Tuesday, May 10, 2011 3:25:45 PM

Page 1

Work Order ID: 69407

Parent Item: D2435

Parent Item Name: Bearpaw, 206



Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	163.0000	3.2	25.6			



UHMW 1" Black



BSI-5-11

Location

MAT018

116554

117321

Loc Qty

163

2

161

Loc Code

117321



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DART AEROSPACE LTD		Work Order:	69407
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.054x45°	✓		Vern	GA-01
B 5.500	+/-0.030	5.501	✓		"	"
C 0.200	+/-0.030	0.202	✓		D-G	GA-08
D R0.250	+/-0.030	R0.250	✓		R-6	ref.
E 0.250	+/-0.010	0.248	✓		Vern	GA-01
F 0.625	+/-0.030	0.625	✓		"	"
G 0.25 x 45°	+/-0.030	0.275x45°	✓		"	"
H 0.375	+/-0.010	0.375	✓		"	"
I 19.000	+/-0.030	19.000	✓		TAPE	GA-12
J 0.950	+0.030/-0.010	0.958	✓		Vern	GA-01
K Ø0.260	+0.005/-0.000	Ø0.260	✓		"	"
L Ø0.930	+/-0.030	Ø0.926	✓		"	"
M 0.30	+0.030/-0.000	0.312	✓		D-G	GA-08
N 0.375	+/-0.030	0.377	✓		Vern	GA-01
O 7.375	+/-0.030	7.377	✓		Vern	CNC-02
P 4.250	+/-0.010	4.250	✓		Vern	GA-01
Q 2.000	+/-0.030	1.999	✓		"	"
R 9.000	+/-0.010	9.000	✓		Vern	CNC-02
S 15.750	+/-0.030	15.750	✓		TAPE	GA-12

Measured by: B.A.	Audited by:	Prototype Approval:	N/A
Date: 11/08/15	Date: 11/08/16	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

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DART**RELEASED**
98.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2435
DATE	TITLE	SHEET 1 OF 2
98.05.19	BEARPAW	SCALE
		1:5

A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09107

11-05-10

EA

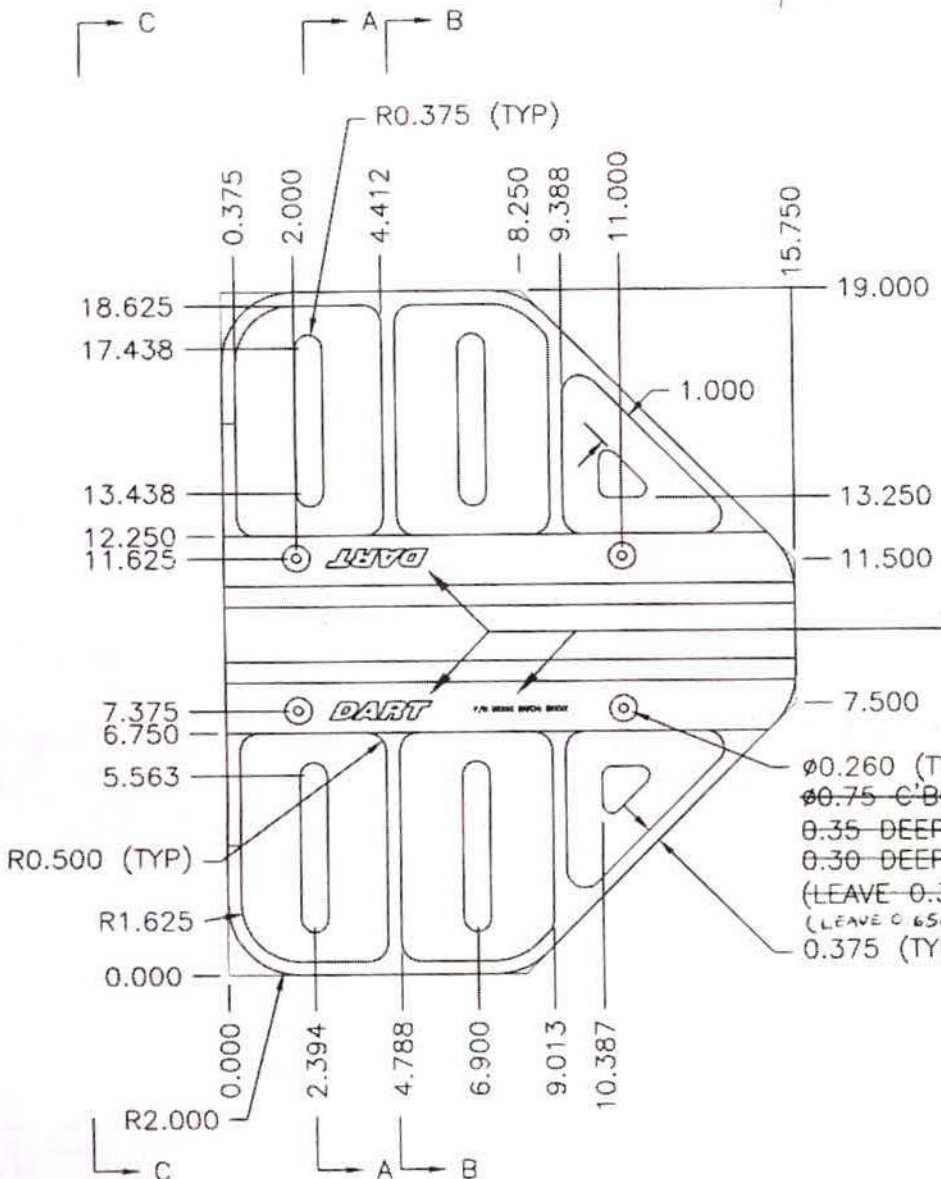
Ø0.260 (TYP) Ø0.93 C'BORE
Ø0.75 C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

E

EA

9143

EFFECTIVE DEOS



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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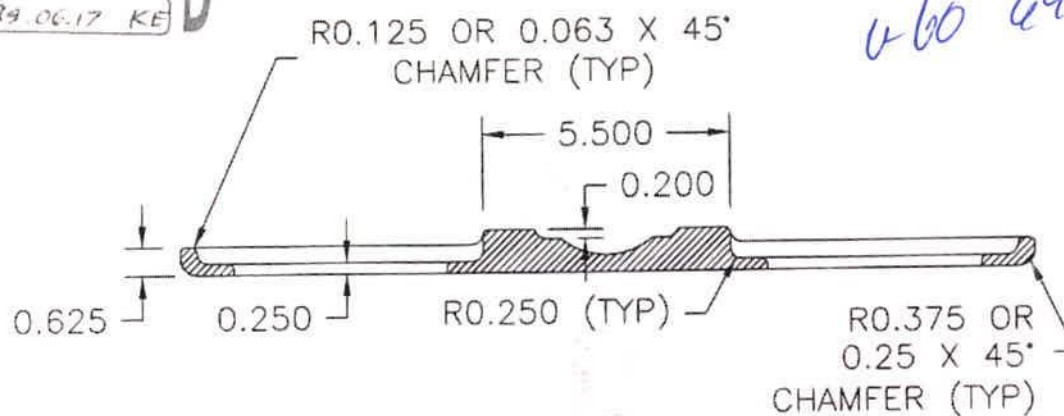
NOTE: Date & initial all entries



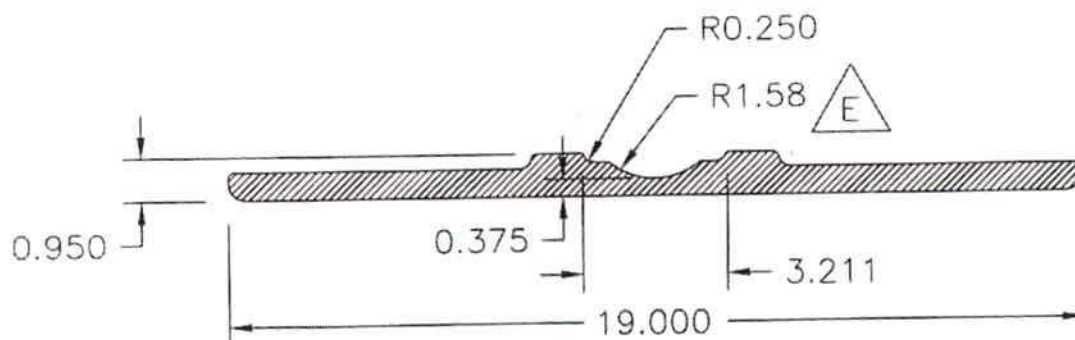
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

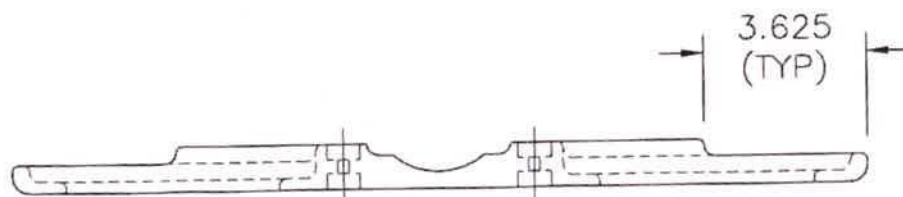
u60 49407



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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